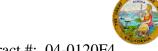
DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453 (707) 649-5493



Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 99.28

WELDING INSPECTION REPORT

Resident Engineer: Siegenthaler, Peter **Report No:** WIR-026226

Address: 333 Burma Road **Date Inspected:** 01-Sep-2011

City: Oakland, CA 94607

OSM Arrival Time: 1200 **Project Name:** SAS Superstructure **OSM Departure Time:** 2200 **Prime Contractor:** American Bridge/Fluor Enterprises, a JV

Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC) Chanxing Island **Location:** Shanghai, China

CWI Name: CWI Present: Yes No Guo Xing Hui **Inspected CWI report:** Yes N/A **Rod Oven in Use:** Yes No No N/A N/A **Electrode to specification:** Yes No Weld Procedures Followed: Yes No N/A N/A **Qualified Welders:** Yes No **Verified Joint Fit-up:** Yes No N/A N/A N/A **Approved Drawings:** Yes No **Approved WPS:** Yes No Yes No N/A **Delayed / Cancelled:**

34-0006 **Bridge No: Component:** Bike Path, Traveler Rail

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector, Dennis Combs, was present during the times noted above for the observations relative to the work being performed.

Bay 19

This QA Inspector observed the following work in progress for Bay 19.

ZPMC was using the Flux Cored Arc Welding(FCAW) process.

ZPMC QC is identified as Guo Xing Hui.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Component: Bike Path PCMK: BK9003A Weld Number:067 Welder: 062749

WPS-B-T-2231-ESAB

Component: Bike Path PCMK: BK9003A Weld Number:068



WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Welder: 062734

WPS-B-T-2231-ESAB

Bay 9

Heat straightening of Traveler Rail 3017TR2 under approved Heat Straightening procedure HSR 10426. The in process temperature was observed as 250°C. The ZPMC QC was identified as Zhu Zhung Jie. The approved HSR procedure stated that a maximum temperature of 650°C with 1-3 numbers of applications was allowed. The distortion that was previously measured and recorded on the HSR was Maximum 5 mm.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.





Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Combs, Dennis	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer